

Work Order ID 78721

78721

Page 1

January-13-12 7:09:04 AM

Item ID: D3140-105 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 12/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 26/01/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3140	Rev F								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00 4 0 Jm 12-8-18
 FLOW CNC Waterjet 1-Cut as per Dwg D3140 Dwg Rev: F Prog Rev: F 2-
2024 .032 Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00 4 0 Jm 12-8-18
 Quality Control

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00 4 0 Jm 12-8-18
 Quality Control

DAS
16
2-3
 12/02/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78721***78721***

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Item ID: D3140-105

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 12/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Deburr if necessary								
140		0.00							
140	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Form as per Dwg D3140								
150		0.00							
150	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Scuff surfaces with 80grit sandpaper per QSI 0062-Deburr. No sharp edges								

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		12/6/12					
170 *170* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	26	12-8-21	
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				H	φ	12-8-21	

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: 028	0.00							
190									
Packaging	Memo	0.00		\$		4x		SK	12/08/22
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

MC3 12/08/23
U 12.08.23

Dart Aerospace Ltd

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Picklist Print

January-13-12 7:09:09 AM

Page 1

Work Order ID: 78721

78721

Parent Item: D3140-105

D3140-105

Parent Item Name: Doubler

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 06-02-08 JLM
 IPP Rev B New dwg rev. ecn781 06.04.18 EC
 IPP rev.C added scuffing NCR 061 EC
 IPP Rev:D As per ECN #829 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.032

Purchased

No

100

sf

106.7000

0.055

~~0.231579~~

0.25

M2024T3S 032

2024-T3 .032 sheet

Jm 12-8-18

Location

Loc Qty

Loc Code

MAT022

106.7

118243

30.7

118523

76

121309

121309

Dart Aerospace Ltd

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NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED

06.11.13

SHOP COPY

RETURN TO

ISSUING OFFICE

UNCONTROLLED COPY

SEE INSTRUCTIONS

W. 1000

NO-78721 M.L.J
12/01/13

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06.11.13

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
ALODINE PER DART QSI 005 4.1



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7822

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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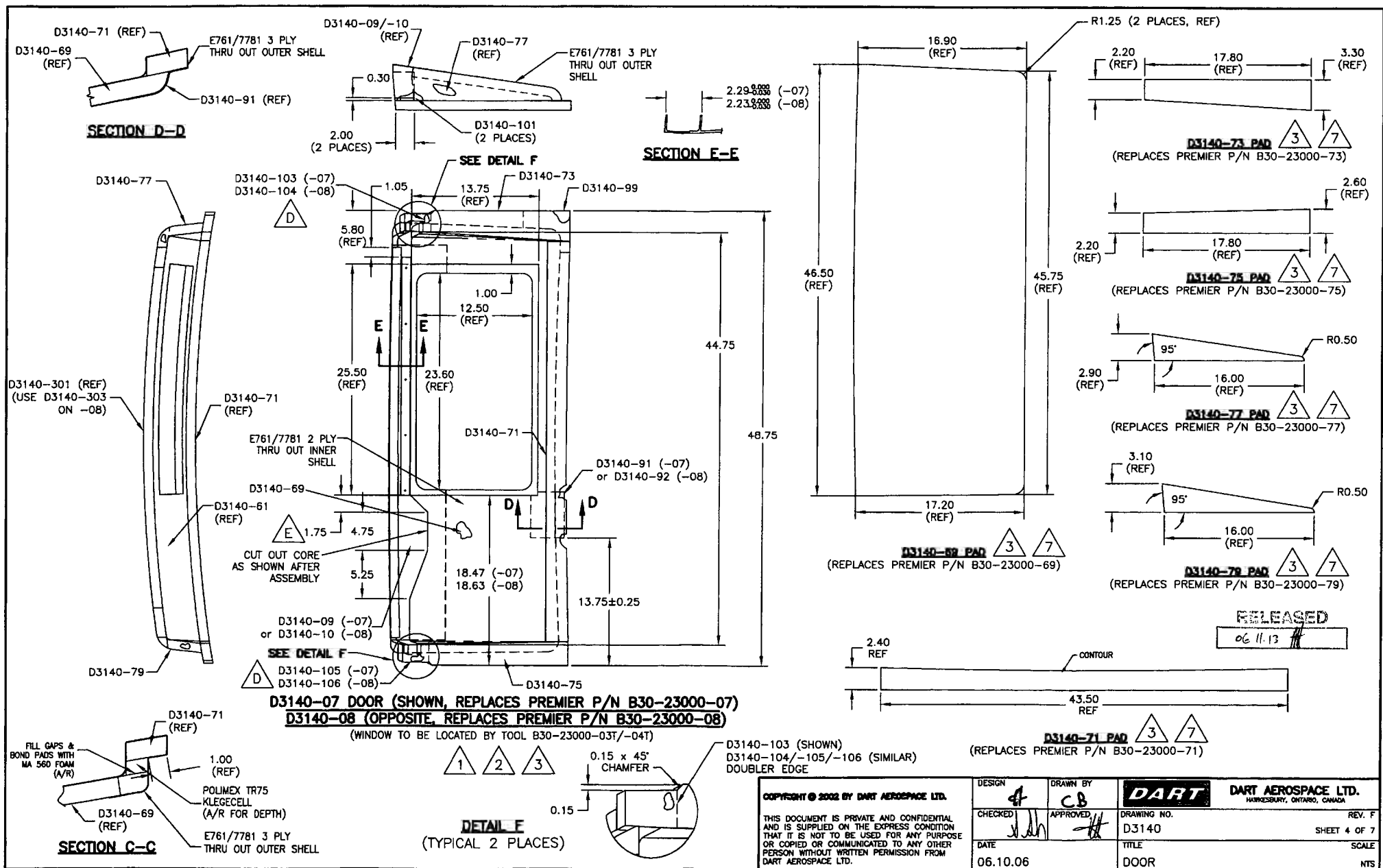
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70721



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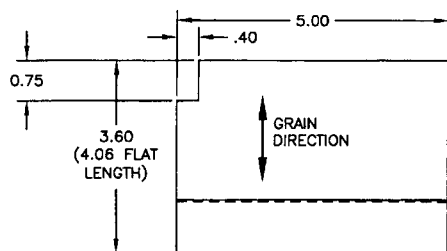
43.00
26.65
3.05
3.20
5.79
0.60
0.35
1.40
1.00
24.25 4 EQ SP
R1.125 (2 PLACES)
D3140-89
NO.40(.098)DIA HOLE MS20426AD3-4 RIVET (5 PLACES)
D3140-85

D3140-09 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-09)
D3140-10 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-10)

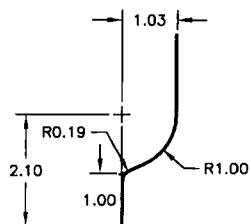
A diagram of a rectangular plate. The top horizontal edge is labeled 2.20. The right vertical edge is labeled 2.80. The bottom horizontal edge is labeled 2.05.


DS140-101 DOUBLE

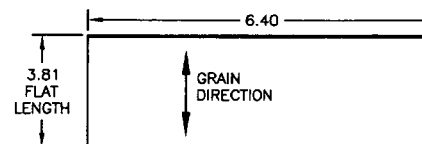
(REPLACES PREMIER P/N B30-23000-101)



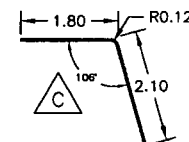
D3140-91F FLAT PATTERN
(USE TO MAKE D3140-91/-92 DOUBLERS)



D3140-92 DOUBLER 
(SHOWN, REPLACES PREMIER P/N B30-23000-92)
D3140-91 DOUBLER
(OPPOSITE, REPLACES PREMIER P/N B30-23000-91)

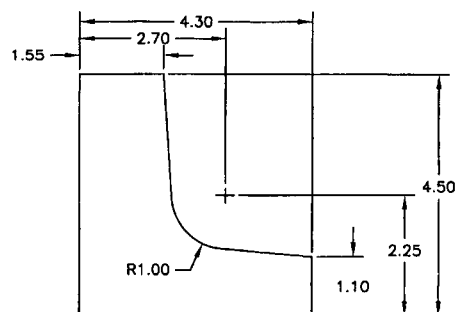


D3140-95 DOUBLER  
(REPLACES PREMIER P/N B30-23000-95)

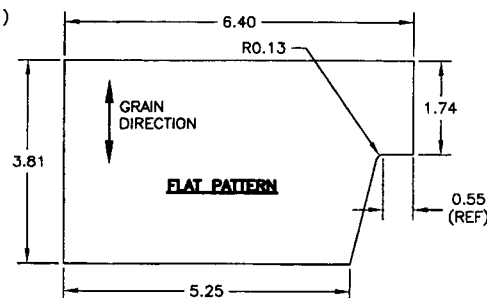


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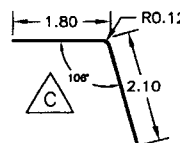
06 11 13



D3140-89 DOUBLER  
(REPLACES PREMIER P/N B30-23000-99)



D3140-97F FLAT PATTERN
(USE TO MAKE D3140-97/-98 DOUBLERS)



BEND DETAIL

D3140-97 DOUBLER

(SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER
(OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

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	DESIGN
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DRAWN BY

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

CHECK8

APPROVED	
----------	--

DRAWING NO.
D3140

REV. F

DATE _____

	TITLE
	DOOR

SCALE

NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

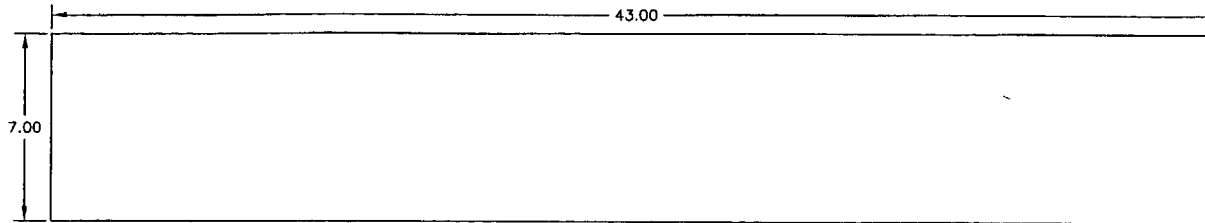
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

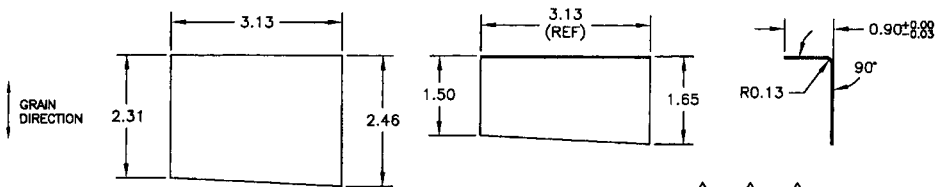
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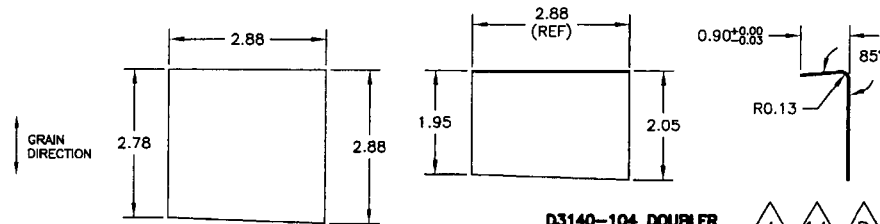
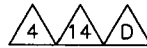


D3140-87 DOUBLER
(REPLACES PREMIER P/N B30-23000-87)



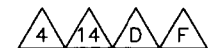
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)

D3140-105 DOUBLER
(REF)
D3140-106 OPPOSITE

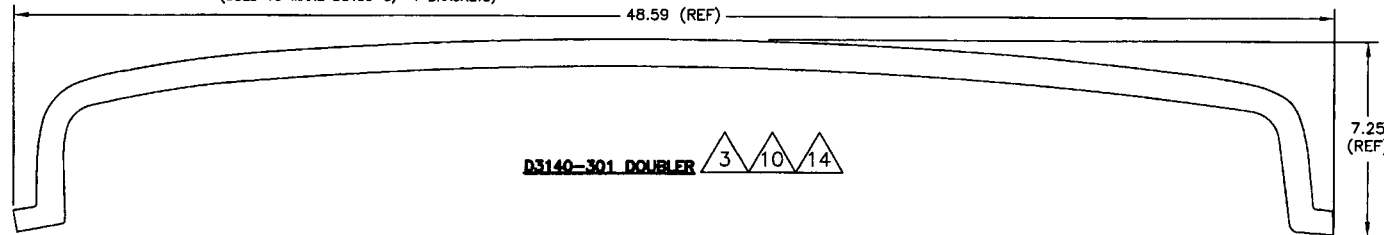


D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)

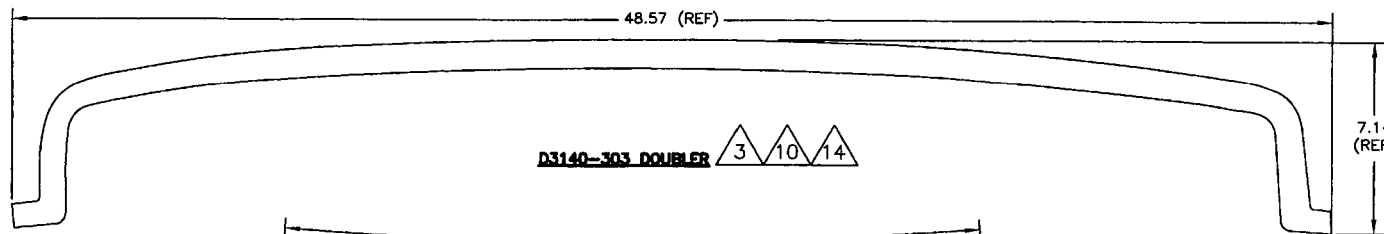
D3140-104 DOUBLER
D3140-103 OPPOSITE



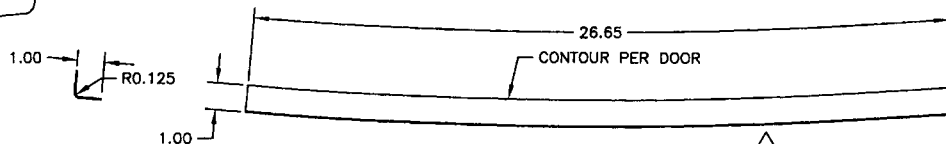
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)



D3140-301 DOUBLER



D3140-303 DOUBLER



D3140-85 ANGLE
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

RELEASED

201113

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CHECKED		APPROVED		DRAWING NO.	REV. F
DATE	06.10.06	TITLE	DOOR	D3140	SHEET 6 OF 7
					SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

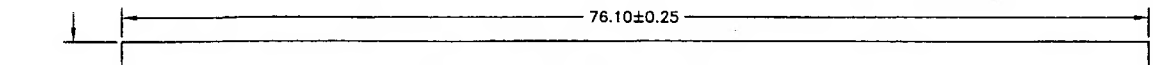
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

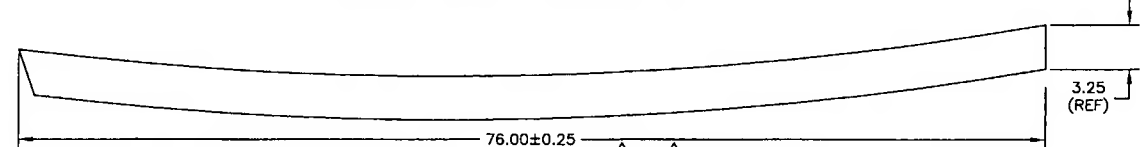
NOTE: Date & initial all entries

70721

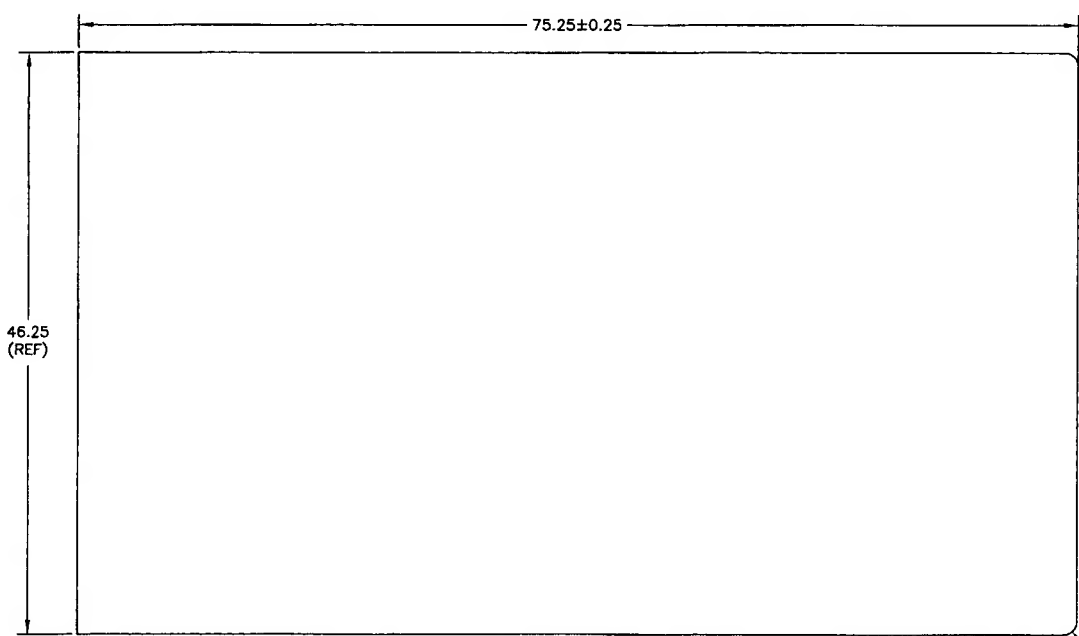


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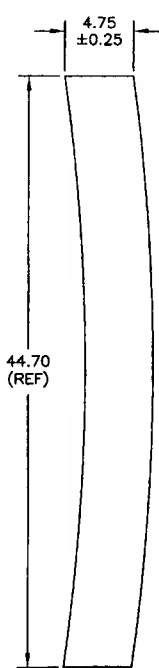
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 (REPLACES PREMIER P/N B30-23000-61)



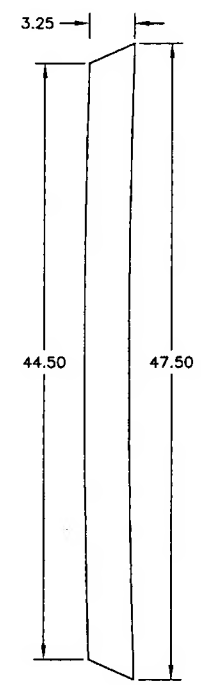
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D3140-59 PAD 7
 (REPLACES PREMIER P/N B30-23000-59)



D3140-57 PAD
 (REPLACES PREMIER P/N B30-23000-57)
3 7



D3140-241 DOUBLER 5 14
 (REPLACES PREMIER P/N B30-23000-241)

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		DATE		D3140	SHEET 7 OF 7
		06.10.06		DOOR	SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

